

Work Order ID 79805

79805

Page 1

February-03-12 10:27:29 AM

Item ID: D3209-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bracket Assembly

Start Date: 03/02/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 17/02/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/02/03

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3209	Rev A

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 1.500" x 1.250" x 1.950" long Bar (+0.030/-0.000)

SL/BL 12/02/09 12 —

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine D3209-1 as per Folio FA345 and Dwg D3209 Identify as D3209-1

Deburr and Tumble

SL/BL 12/02/09 12 —

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

SL/BL 12/02/09 12 —

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79805

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Page 2

Item ID: D3209-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket Assembly
 Start Date: 03/02/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 17/02/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		JK 12-02-10					
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							12 BL 12-2-10.
150 *150* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo Note: Cover the hole for D3209-1 before powder coat. START TIME: 3:00 OVEN TEMPERATURE: FINISH TIME: 3:30	0.00 0.00							12XPM 12/02/13

m 118489

3200F

3:30

W/O:		WORK ORDER CHANGES					
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Work Order ID 79805***79805***

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Item ID: D3209-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket Assembly

Start Date: 03/02/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 17/02/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

12x 6 11 12/02/14

161

0.00

161

Small Fab

Memo

0.00

Small Fab

press fit bushing as per dwg

12/02/14 12

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Quality Control

5.2/02/14

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 4

Item ID: D3209-041 Accept ***N900040100*** Setup Start ***NS1***
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 Item Name: Bracket Assembly
 Start Date: 03/02/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 17/02/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* Packaging Packaging	Identify as per dwg & Stock Location <u>G-1</u> Memo	0.00 0.00							<u>12/02/14</u> (12)
190 *190* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>12/2/15</u> (12)

12-02-14 (12)

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

February-03-12 10:27:33 AM

Page 1

Work Order ID: 79805

79805

Parent Item: D3209-041

D3209-041

Parent Item Name: Bracket Assembly

Start Date: 03/02/2012

Required Date: 17/02/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP A04.06.09New issueKJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3209-3		Manufactured	No			100	Each	19.0000	1	6			
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D3209-3

Bushing

**

Location

Loc Qty

Loc Code

ST033

19

40930

19

M6061T6B1.500X01.25

Purchased

No

170

f

13.1170

0.175

1.105263

0

M6061T6B1 500X01 250

**

6061-T6 Bar 1.50 x 1.25

Location

Loc Qty

Loc Code

MAT003

13.117

118071

0.112

119513

13.005

EP 5/2/02/14

2.3 BL 12/02/10

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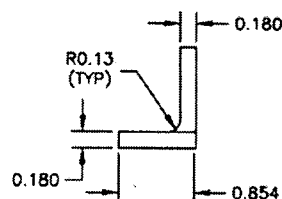
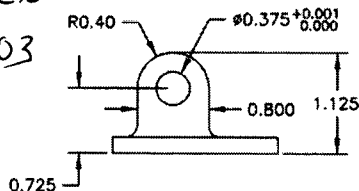
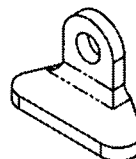
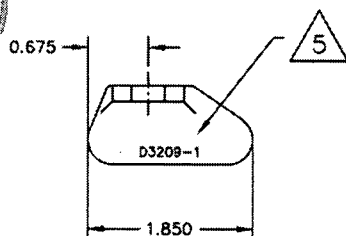


DESIGN TF	DRAWN BY TF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3209	REV. A SHEET 1 OF 1
DATE 04.01.27		TITLE BRACKET	SCALE 1:2
A	04.01.27	NEW ISSUE	

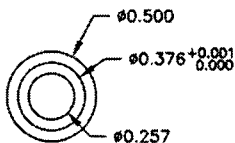
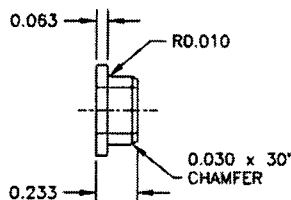
RELEASED
04.04.05

COPY
TO COPY
ENDMENT
ER

79805 M.L.S
12/02/03



D3209-1 BRACKET

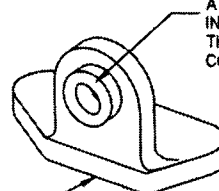


**D3209-3 BUSHING
SCALE 1:2**



D3209-041 ASSEMBLY

D3209-3 BUSHING
PRESS FIT, HEAD
AT THIS FACE
INSTALL AFTER
THE CONVERSION
COAT



D3209-1 BRACKET; D3209-3 BUSHING

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
ALUMINUM BAR (M6061T6B)
- 3) MATERIAL: AISI 303 SS (M303R)
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 5) ENGRAVE DART P/N AS SHOWN
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE INCHES

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